

Date: Thursday, 07/08/2008 3:31:53 PM
User: Melanie Fauteux

Process Sheet

Customer:	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE AND LOCK- DOWN ASSY
Job Number	: 41064	Part Number	: D3451043
Estimate Number	: 13525	Drawing Number	: D3451 REVA
P.O. Number	:	Project Number	: N/A
This Issue	: 07/08/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Revision	: A
First Issue	: / /	Type	: LARGE FAB ASSY
Previous Run	:	Material	:
Written By	:	Due Date	: 14/08/2008
Checked & Approved By	: <u>MF 08-08-07</u>	Qty:	5 Um: Each
Comment	: Est Rev:A 08-06-27 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34513	Tube Handle Arm
-----	--------	-----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Tube Handle Arm
batch: B 39756 ✓

SP 08-08-11 (10X) (5X)

2.0	GP211	Rubber Handle
-----	-------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Rubber Handle
batch: M 108392

SP 08 108 / 14 (3)

3.0	PB6743001103	Tube Handle
-----	--------------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Tube Handle
batch: 341066

SP 08-08-11 (5X)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1
1- weld as per dwg PB67-43001

SP 08-08-11 (5X)

5.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

408/08/11 (5)

Date: Thursday, 07/08/2008 3:31:53 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE AND LOCK- DOWN ASSY

Job Number: 41064

Part Number: D3451043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/08/14 (+8)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-h / m2 08.08.11

(SX)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00
320 OF
8:30

m-h 08/08/12

(SX)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/08/12 (5)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble rubber handle as per dwg PB67-43001

SB 08/08/14 (5)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/08/19 (45)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FAE

SS 08/08/26 (2)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



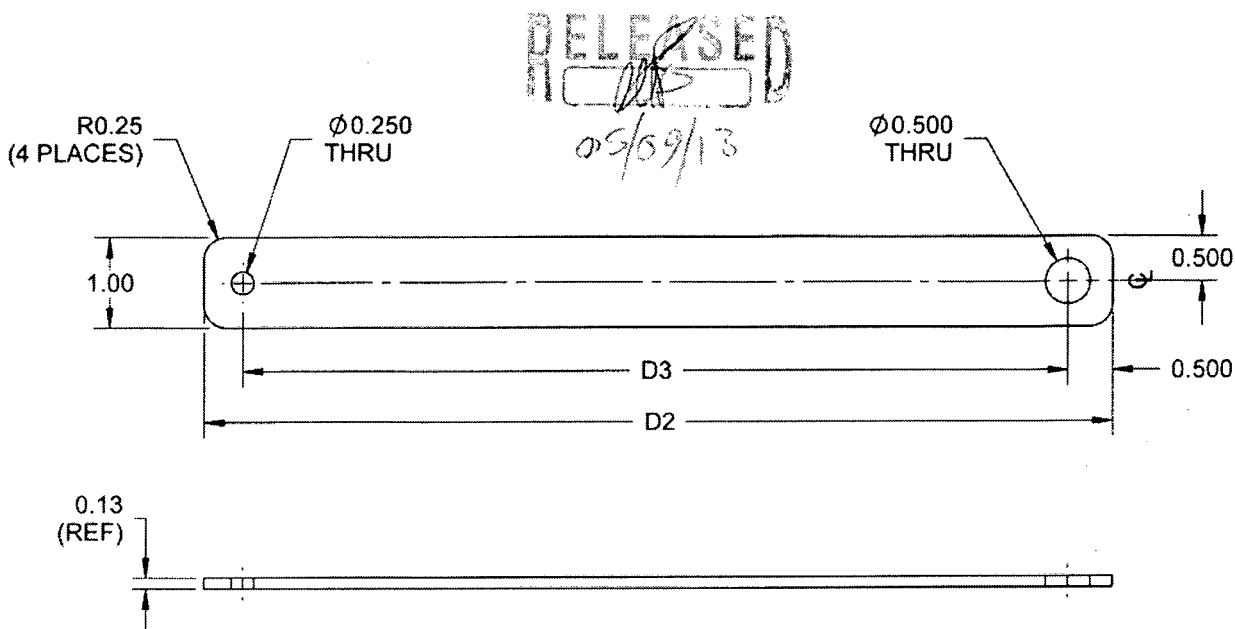
Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

W 08.08.26



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3451	REV. A SHEET 2 OF 2
DATE 05.08.25		TITLE HANDLE & LOCK-DOWN ASS'Y	SCALE 1:2



P/N	D2: CUT LENGTH	D3: HOLE SPACING
D3451-1	10.25	9.200
D3451-3	10.63	9.700
D3451-5	8.00	7.100
D3451-7	10.00	9.000

- 41064

D3451-1/-3/-5/-7 TUBE HANDLE ARMS

D3451-1 SUPERSEDES PREMIER P/N B67-43001-303

D3451-5 SUPERSEDES PREMIER P/N B67-43001-301

D3451-7 SUPERSEDES PREMIER P/N B67-43001-101

NOTES:

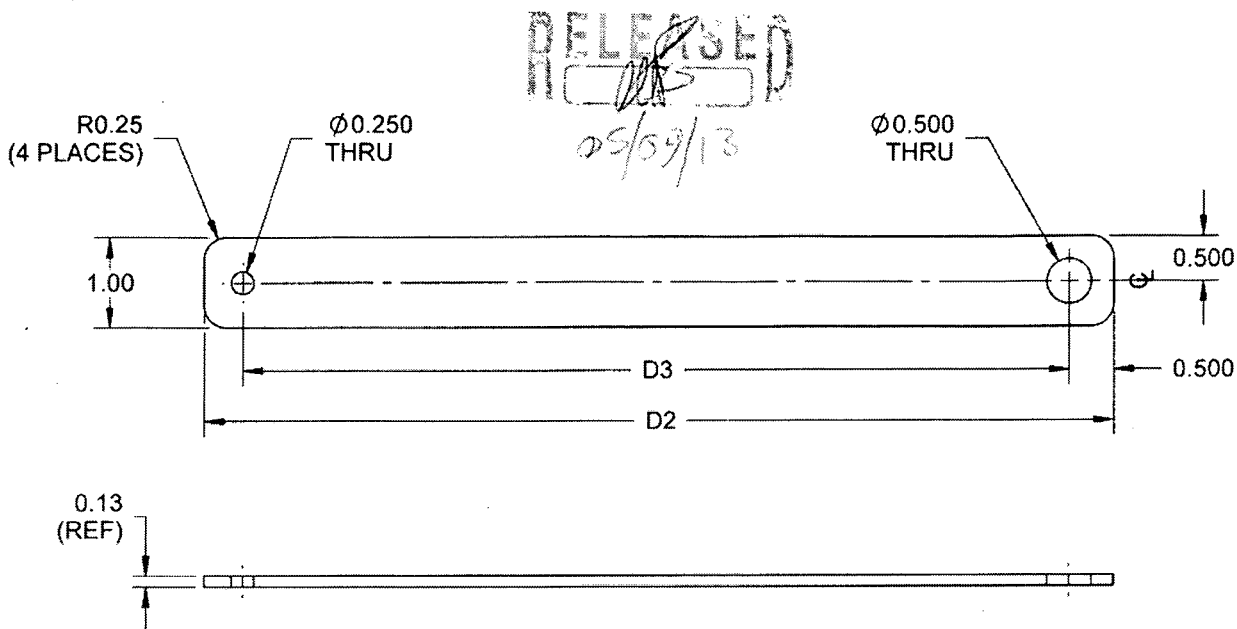
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.125)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3451	REV. A SHEET 2 OF 2
DATE 05.08.25		TITLE HANDLE & LOCK-DOWN ASS'Y SCALE 1:2	



P/N	D2: CUT LENGHT	D3: HOLE SPACING
D3451-1	10.25	9.200
D3451-3	10.63	9.700
D3451-5	8.00	7.100
D3451-7	10.00	9.000

#41064

D3451-1/-3/-5/-7 TUBE HANDLE ARMS

D3451-1 SUPERSEDES PREMIER P/N B67-43001-303

D3451-5 SUPERSEDES PREMIER P/N B67-43001-301

D3451-7 SUPERSEDES PREMIER P/N B67-43001-101

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.125)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

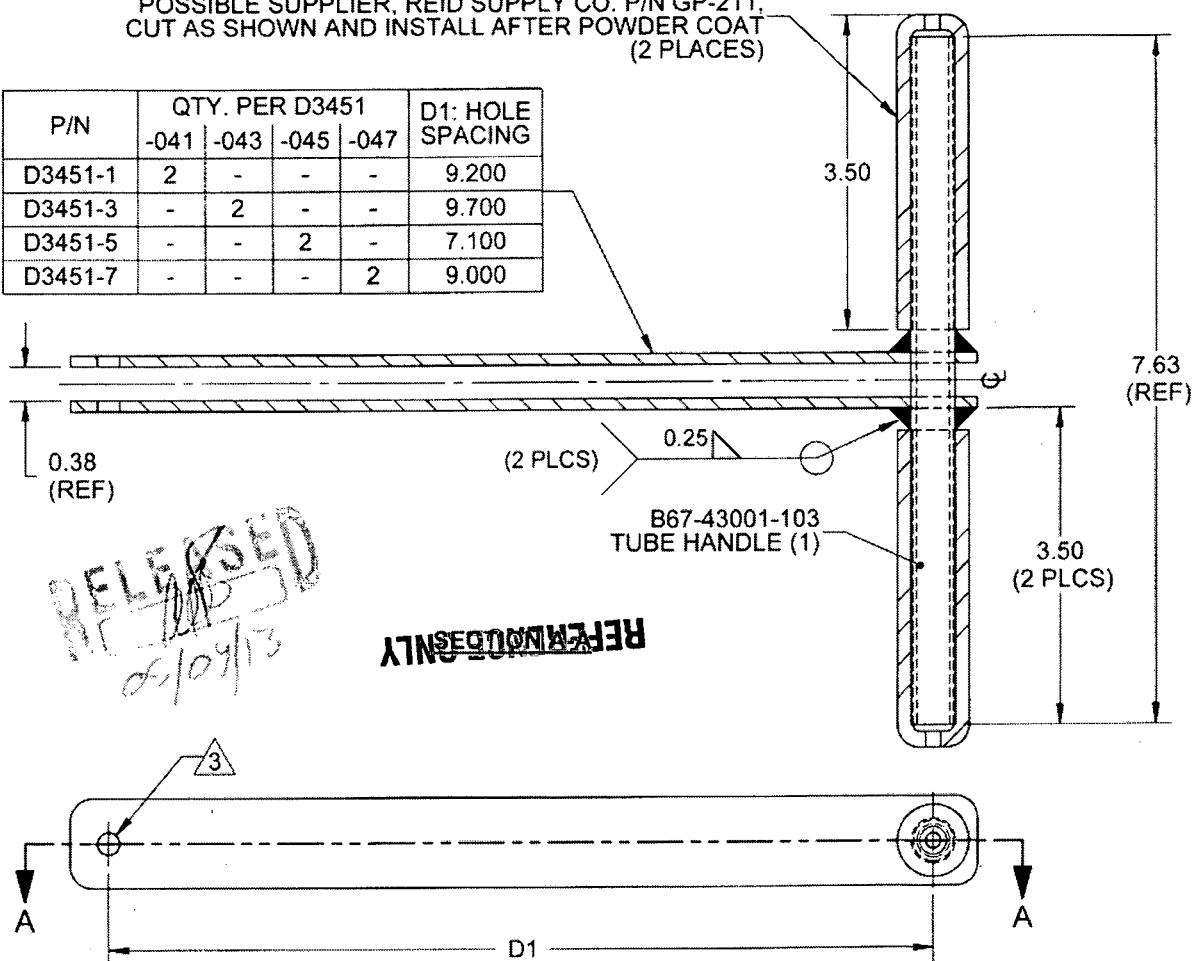
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3451	REV. A SHEET 1 OF 2
DATE 05.08.25	TITLE HANDLE & LOCK-DOWN ASS'Y		SCALE 1:2
A	05.08.25	NEW ISSUE	

0.50" ID x 4.875" LONG BLACK VINYL HANDLE,
POSSIBLE SUPPLIER, REID SUPPLY CO. P/N GP-211,
CUT AS SHOWN AND INSTALL AFTER POWDER COAT
(2 PLACES)

P/N	QTY. PER D3451				D1: HOLE SPACING
	-041	-043	-045	-047	
D3451-1	2	-	-	-	9.200
D3451-3	-	2	-	-	9.700
D3451-5	-	-	2	-	7.100
D3451-7	-	-	-	2	9.000



D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y

D3451-041 SUPERSEDES PREMIER P/N B67-43001-41

D3451-045 SUPERSEDES PREMIER P/N B67-43001-39

D3451-047 SUPERSEDES PREMIER P/N B67-43001-55

NOTES:

- 1) WELD PER DART QSI 004
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) PART IS SYMETRICAL ABOUT CENTER LINE.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

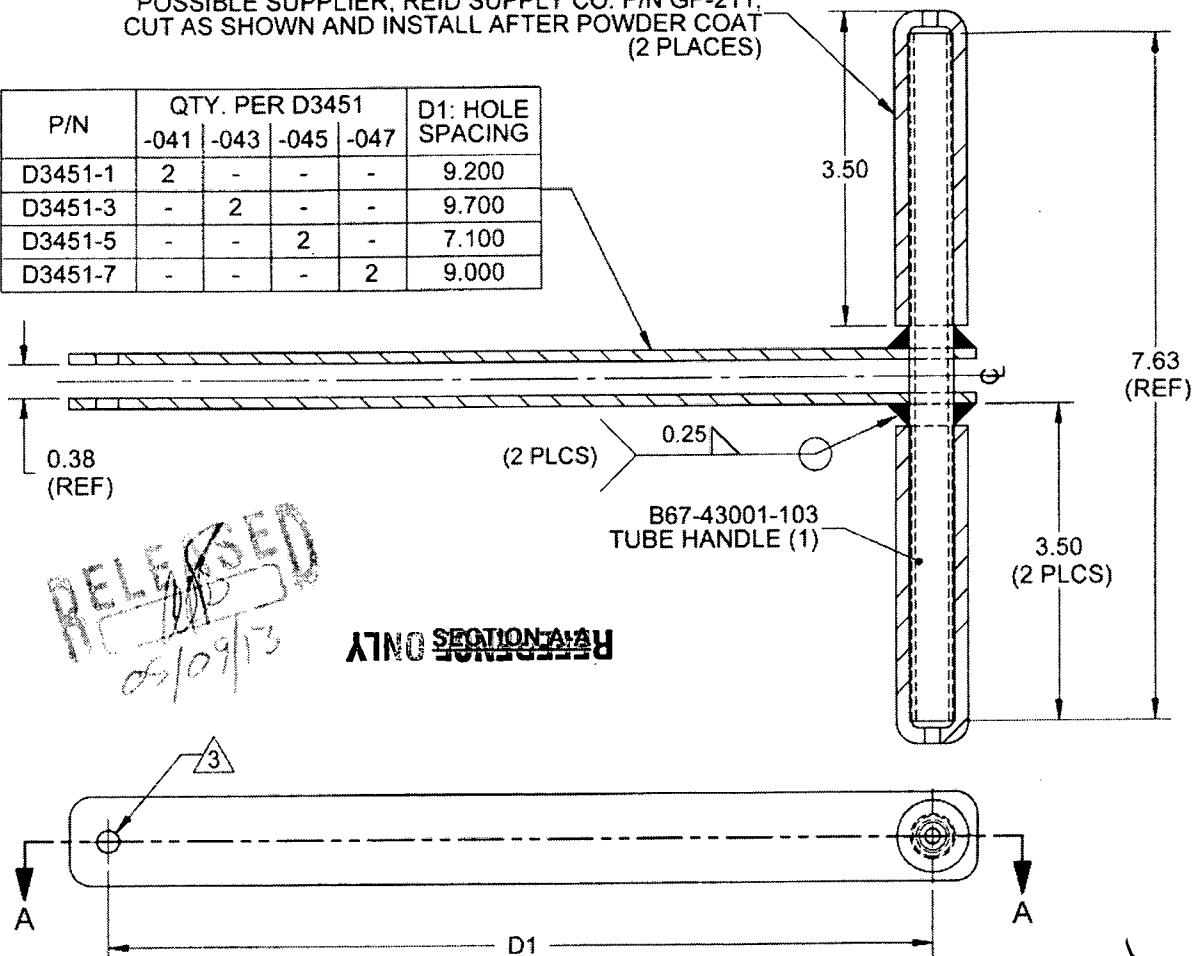
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE HAWKESBURY, ONTARIO, CAN
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3451
DATE 05.08.25	TITLE HANDLE & LOCK-DOWN ASS'Y 1:2	
A	05.08.25	NEW ISSUE

0.50" ID x 4.875" LONG BLACK VINYL HANDLE,
POSSIBLE SUPPLIER, REID SUPPLY CO. P/N GP-211.
CUT AS SHOWN AND INSTALL AFTER POWDER COAT
(2 PLACES)

P/N	QTY. PER D3451				D1: HOLE SPACING
	-041	-043	-045	-047	
D3451-1	2	-	-	-	9.200
D3451-3	-	2	-	-	9.700
D3451-5	-	-	2	-	7.100
D3451-7	-	-	-	2	9.000



D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y

D3451-041 SUPERSEDES PREMIER P/N B67-43001-41

D3451-045 SUPERSEDES PREMIER P/N B67-43001-39

D3451-047 SUPERSEDES PREMIER P/N B67-43001-55

NOTES:

- 1) WELD PER DART QSI 004
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) PART IS SYMMETRICAL ABOUT CENTER LINE.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.